

Work Order ID 136799

September 09, 2015 12:55:01 PM

136799

*Order to ship
Sept 25*

Page 1

Item ID: D5155-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head (205)
 Start Date: 9/9/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/23/2015 Req'd Qty: 4.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *SA* Date: *20150909* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5155	B

100	Cut blanks as per folio	0.00							DAS 08 9-89
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK AT 4.900"								

110		0.00							DAS 08 9-89
110									
HAAS 5AXIS	Memo	0.00							
HAAS CNC vertical machine #5	MACHINE AS PER DWG & FOLIO FB349/ D5155-9								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>B</u>								

DO NOT BUFF OR POLISH PART

DEBURR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

136799

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/9/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2015 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Work Order ID 136799

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Page 3

Item ID: D5155-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head (205)
 Start Date: 9/9/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/23/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
150									
Outsource4	Memo	0.00							
Outsource process - Anodize	ISSUE P/O TO ATG: <u>29893</u>								
	ANODIZE BLACK AS PER MIL SPEC AND DWG								
	C OF CO IS REQUIRED								
155	Receive & Inspect for Damage & Mat'l Certs	0.00							
155									
Packaging	Memo	0.00							
Packaging									
158	QC5- Inspect part completeness to step on W/O	0.00							
158									
QC	Memo	0.00							
Quality Control									

CY SEP 25 2015 2

15/09/2015 2 SEP

② 15-09-29 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 136799

September 09, 2015 12:55:01 PM

136799

Page 4

Item ID: D5155-9

Accept

N19000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head (205)

Start Date: 9/9/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>St 155</u>	0.00							
160						SEP 29 2015		DAG 6 9-89	
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

SH 20150929

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

September 09, 2015 12:55:16 PM

Page 1

Work Order ID: 136799

136799

Parent Item: D5155-9

D5155-9

Parent Item Name: Co-Pilot Collective Head (205)

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV.A NEW ISSUE JFS 14/12/09 VERIFIED BY: JLM IPP REV:B
15.07.02 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased			No	100	f	7.6120	0.409	0.430526			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

B.A 15/09/15

Location

Loc Qty

Loc Code

MAT004

7.612

→ m132320

1.612

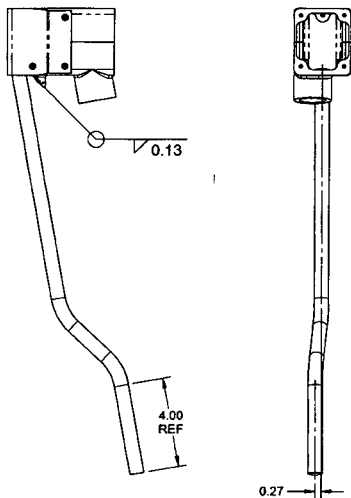
m132772

6

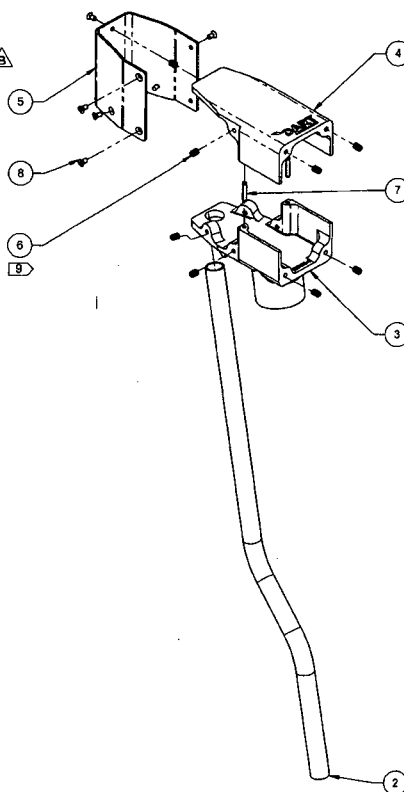
0.825 ft

136 799 5th
20150909

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5155-1	CO-PILOT COLLECTIVE HEAD (205)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS18562-223	SLOTTED SPRING PIN
8	7	MS24893-24B	SCREW, CSK 100°



D5155-041 WELDING DETAIL



D5155-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IB CLASS 2 AFTER WELDING
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 1.08 lbs
 8) WELD PER DART QSI 004
 9) INSTALL AFTER ANODIZING

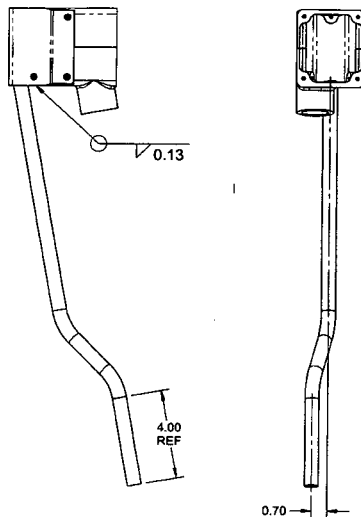
RELEASED

A.R. 2015 JUL 02 Rev 15-577

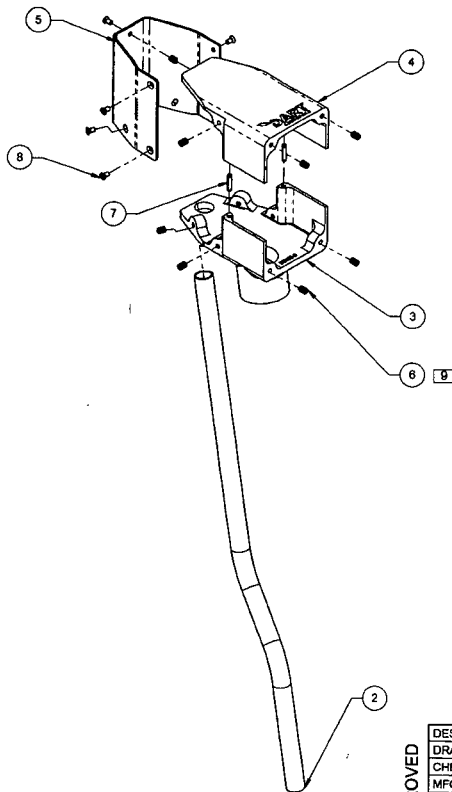
B	REVISE DIM: ZN D3-7, REVISE NOTE 2: ZN A8-13, A8-14, REVISE LENGTH OF PIN: ZN D6-1, D6-2, D6-3, D6-4, REVISE DEPTH: ZN C7-5, C7-7, C7-8, C7-11, C8-13, C4-14, REVISE DIM: ZN C7-5, C7-7, C7-8, C8-11, B7-13, B7-14, B2-5, B2-7, B2-9, B2-11, D5-13, C4-14, D6-4, D8-9, D8-10, D8-8, D5-10, D5-12, B8-7, D7-12, C7-5, C7-7, C7-9, C8-11, D2-13, D2-14	VS	15.05.21
	A	NEW ISSUE	VS
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED, UNLESS SUPPLIED BY THE OFFICE OF THE CHIEF OF DEFENSE AND IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-7	CONDUIT
3	1	D5155-3	CO-PILOT COLLECTIVE HEAD (212)
4	1	D5155-11	CO-PILOT COLLECTIVE HEAD (212)
5	1	D5156-11	BACK PLATE
6	11	90296A108	HELL-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24683-246	SCREW, CSK 100*



D5155-043 WELDING DETAIL



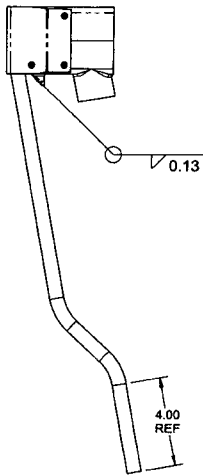
D5155-043 CO-PILOT COLLECTIVE HEAD ASSY (212)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.20 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL AFTER ANODIZING

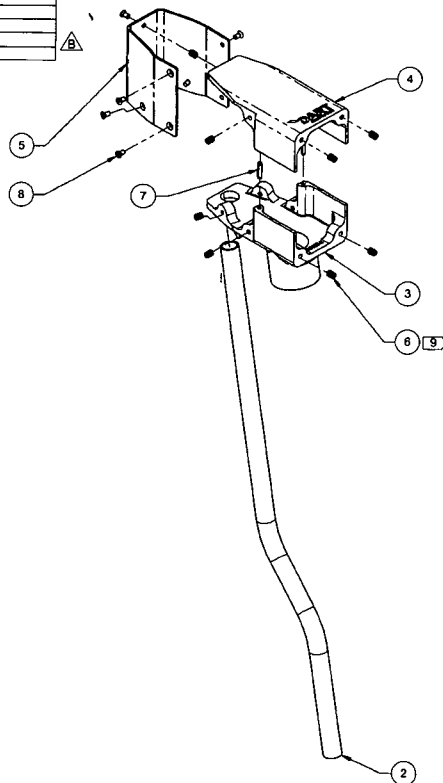
RELEASED
#4 2015 JUL 02

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 2 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCTION, OR FOR ANY OTHER PURPOSE, WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5155-5	CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS10562-223	SLOTTED SPRING PIN
8	7	MS24693-246	SCREW, CSK 100°



D5155-045 WELDING DETAIL



D5155-045 CO-PILOT COLLECTIVE HEAD ASSY (EAGLE SINGLE)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.06 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL AFTER ANODIZING

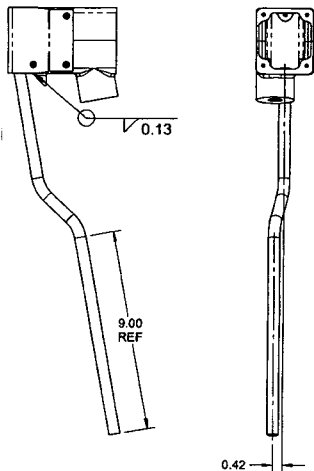
APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5155	REV. B SHEET 3 OF 14
TITLE CO-PILOT COLLECTIVE HEAD	SCALE NTS
COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

RELEASED
15 JUL 02

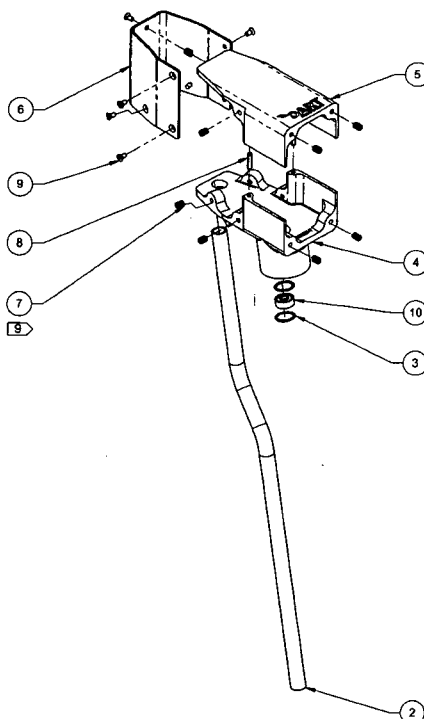
ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5054-1	CONDUIT
3	2	D5073-1	SNAP RING
4	1	D5155-7	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
6	1	D5156-9	BACK PLATE
7	11	80296A108	HELI-COIL INSERT (6-32 X 0.276)
8	2	MS16562-223	SLOTTED SPRING PIN
9	7	MS24893-24B	SCREW, CSK 100°
10	1	MS27641-3	BEARING



D5155-047 WELDING DETAIL

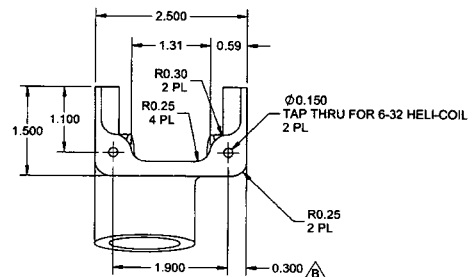
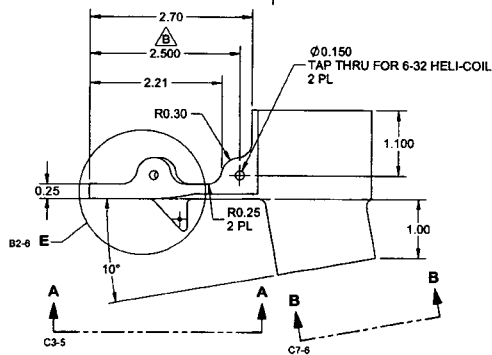
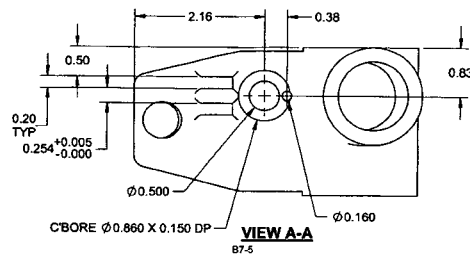
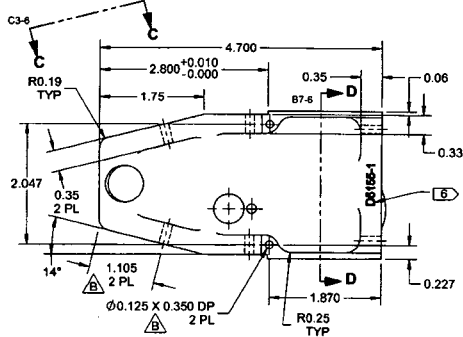
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.14 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL AFTER ANODIZING

D5155-047 CO-PILOT COLLECTIVE HEAD ASSY
FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED



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 15 JUL 02

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD	

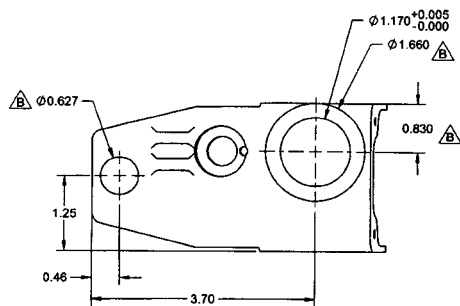


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A.P. 2015 JUL 02

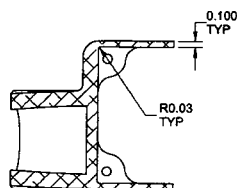
- NOTES:**
 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4118)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061 T6B
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
 OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 7) WEIGHT: 0.47 lbs
 8) UNDIMENSIONED FEATURES ARE DEFINED BY D5155-1.SLDPR

D5155-1 CO-PILOT COLLECTIVE HEAD (205)

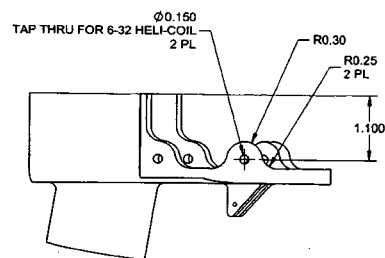
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 5 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD	



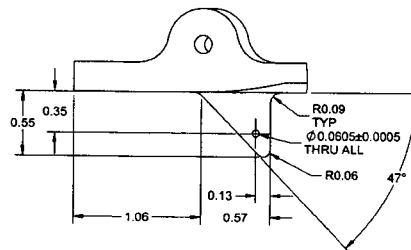
VIEW B-B
BS-5



SECTION D-D
D6-5



VIEW C-C
D7-5



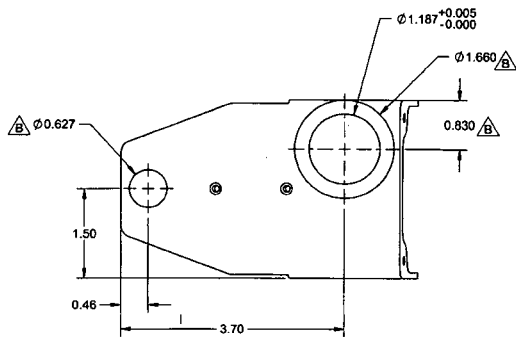
DETAIL E
B7-5

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A.E 2015 JUL 02

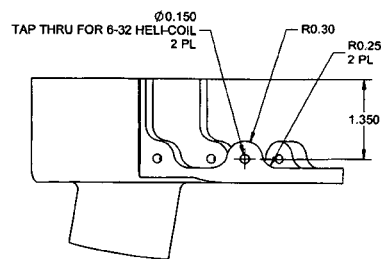
- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-1 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

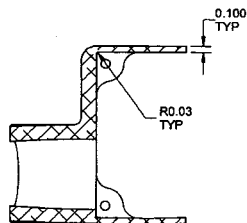
APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 8 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW G-G
96-7



VIEW H-H
07-7



SECTION I-I
06-7

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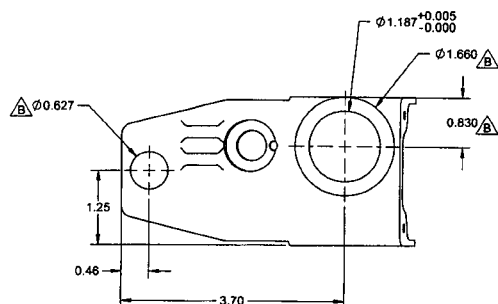
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

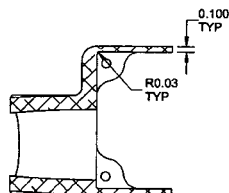
APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 8 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	
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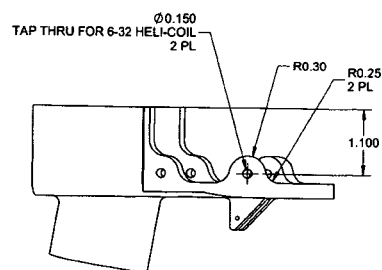
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS A PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PROJECT OR PROJECTS FOR WHICH IT WAS PREPARED. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REASON UNLESS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD. ANY UNAUTHORIZED REPRODUCTION OR DISTRIBUTION OF THIS DOCUMENT IS STRICTLY PROHIBITED.	
DRAWN	VS		REV. B
CHECKED	RF		SHEET 9 OF 14
MFG. APPR.	JFS		SCALE
APPROVED	HS		NTS
DE APPR.	DS		
DATE	15.05.21		



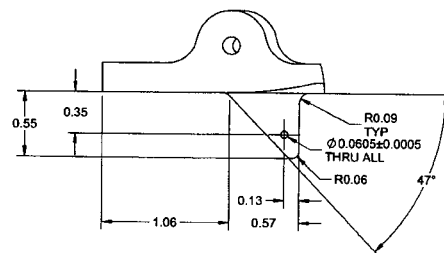
VIEW K-K
86-9



SECTION M-M
D6-9



VIEW L-L
D7-9



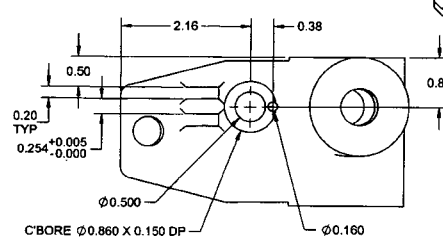
DETAIL N
87-9

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A.P. 2015 JUL 02

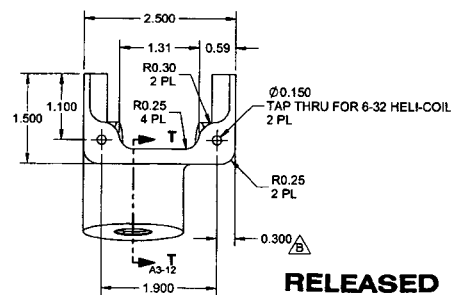
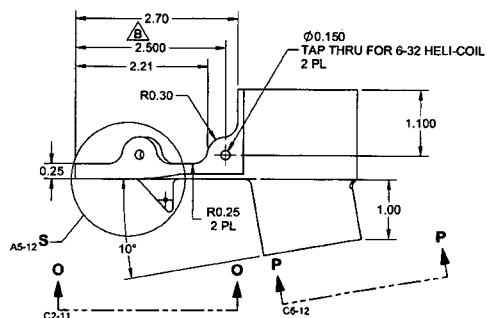
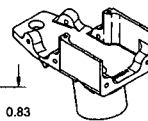
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
DETAIL VIEWS

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 10 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW O-O



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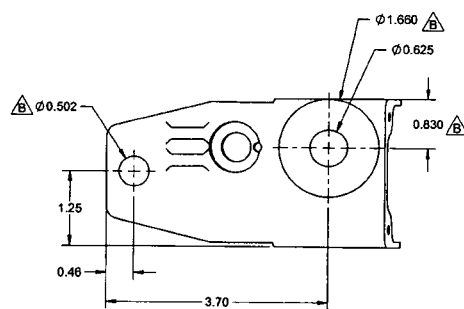
A.P. 2015 JUL 02

NOTES:
1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

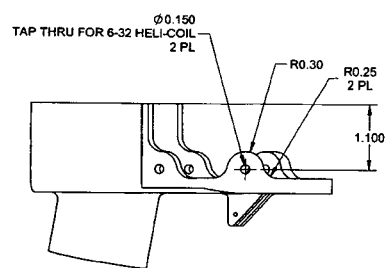
- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
7) WEIGHT: 0.56 lbs
8) UNDIMENSIONED FEATURES DEFINED BY D5155-7.SLDPRT

D5155-7 CO-PILOT COLLECTIVE HEAD (205)

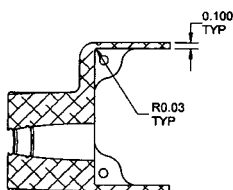
DESIGN	VS	DAWRIGHT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD SCALE NTS
DRAWN	VS	
CHECKED	RF	
MFG. APPR.	JFS	
APPROVED	HS	
DE APPR.	DS	
DATE 15.05.21		COPYRIGHT © 2013 BY DAWRIGHT AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL IT IS NOT TO BE USED FOR ANY PURPOSE, OR INFORMATION DISCLOSED TO ANY OTHER PERSON WITHOUT IT BEING FIRSTLY APPROVED BY THE PERSON WHO ISSUED IT



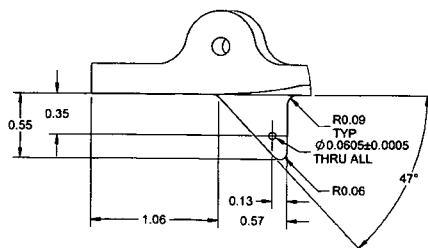
VIEW P-P
85-11



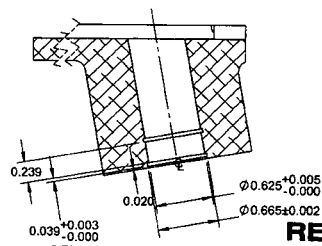
VIEW Q-Q
D7-11



SECTION R-R
C6-11



DETAIL S
86-11



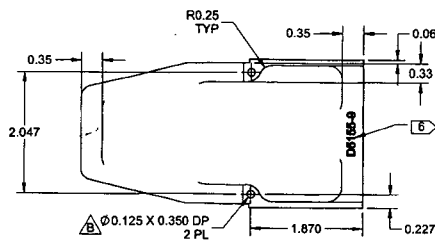
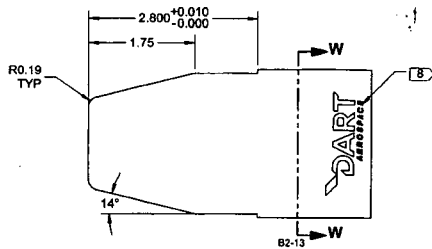
SECTION T-T
B2-11

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A.R. 2015 JUL 02

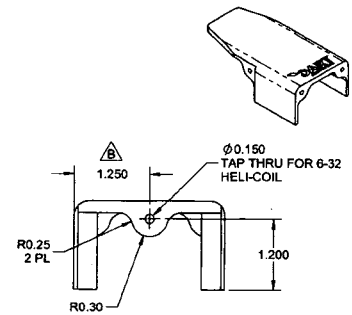
- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-7 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

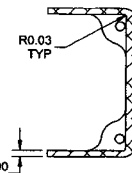
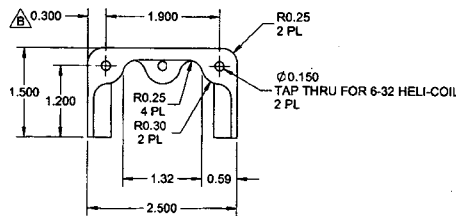
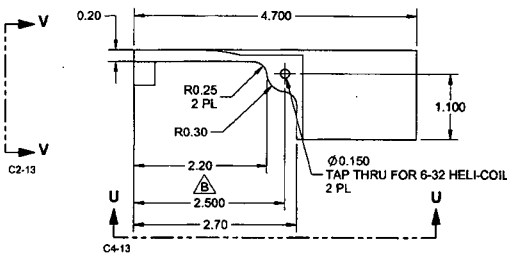
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 12 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW U-U
B7-13



VIEW V-V
B8-13



SECTION W-W
D6-13

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4.8.2015 JUL 02

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6S
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.31 lbs
 - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
 - 9) UNDIMENSIONED FEATURES DEFINED BY D5155-9.SLDPRT

D5155-9 CO-PILOT COLLECTIVE HEAD (205)

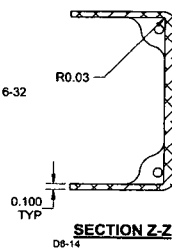
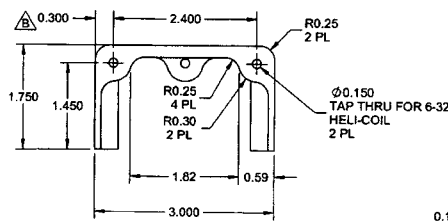
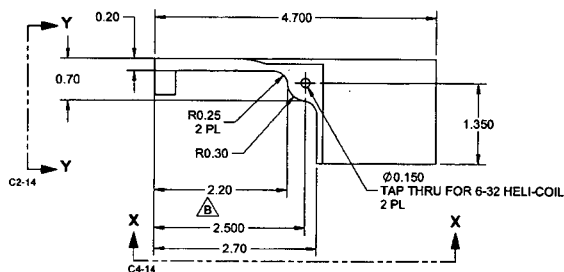
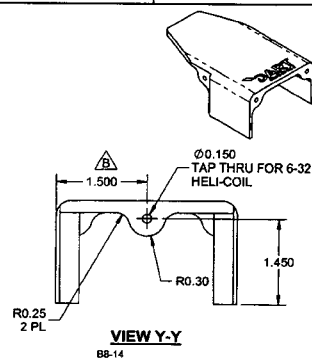
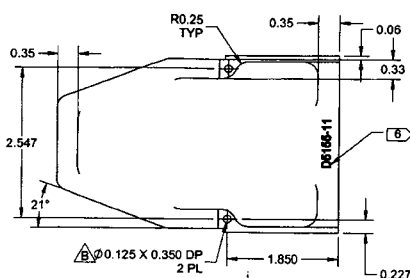
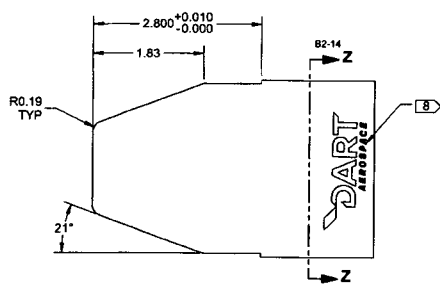
APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. B
D5155	SHEET 13 OF 14
TITLE	SCALE
CO-PILOT COLLECTIVE HEAD	NTS

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NOTES:

1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010

7) WEIGHT: 0.36 lbs

8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

9) UNDIMENSIONED FEATURES DEFINED BY D5155-11.SLDPRT

D5155-11 CO-PILOT COLLECTIVE HEAD (212)

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A.R. 2015 JUL 02

DESIGN	VS	DART AEROSPACE LTD
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D5155
MFG. APPR.	JFS	REV. B
APPROVED	HS	SHEET 14 OF 14
DE APPR.	DS	SCALE
DATE	15.05.21	NTS

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DART AEROSPACE LTD		Work Order:	136799
Description: CO-PILOT COLLECTIVE HEAD (205)		Part Number:	D5155-9
Inspection Dwg: D5155 Rev: B		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.800	+0.010 / -0.000	2.801	✓		H-G	31006
14°	+/- 1/2°	14°	✓		Angle M	CNC-17
2.047	+/-0.005	2.045	✓		Vern	GA-13
0.35	+/-0.030	0.351	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-G	ref.
0.35	+/-0.030	0.349	✓		Vern	GA-13
0.06	+/-0.030	0.063	✓		D-G	GA-08
0.33	+/-0.030	0.329	✓		Vern	GA-13
0.227	+/-0.010	0.226	✓		H-G	31006
1.870	+/-0.010	1.867	✓		"	"
φ.125 x.350	+0.004 / -0.001 / +/-0.010	φ.124 x.346	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-G	ref.
1.250	+/-0.010	1.249	✓		H-G	31006
φ0.150	+0.005 / -0.001	φ0.151	✓		Vern	GA-13
1.200	+/-0.010	1.201	✓		H-G	31006
0.20	+/-0.030	0.201	✓		Mic	118-120
4.700	+/-0.010	4.699	✓		Vern	GA-13
1.100	+/-0.010	1.100	✓		H-G	31006
φ0.150	+0.005 / -0.001	φ0.151	✓		Vern	GA-13
2.70	+/-0.030	2.701	✓		H-G	31006
2.500	+/-0.010	2.498	✓		"	"
2.20	+/-0.030	2.200	✓		"	"
2.500	+/-0.010	2.497	✓		Vern	GA-13
1.200	+/-0.010	1.201	✓		H-G	31006
1.500	+/-0.010	1.500	✓		Vern	GA-13
0.300	+/-0.010	0.299	✓		H-G	31006
1.900	+/-0.005	1.900	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-G	ref.
φ0.150	+0.005 / -0.001	φ0.151	✓		Vern	GA-13
R0.032	+/-0.030	R0.032	✓		R-G	ref.
0.100	+/-0.010	0.100	✓		Mic	GA-03

DAS

Measured by: J.A.	DAS 08 9-89	Checked by:	QC Inspector:
Date: 15/09/15		Date: 15-09-23	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63934

Date: 29-Sep-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
2 ea	Part: D5155-9 CO-PILOT HEAD BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150732 PO: PO29893 Line:	Rev: B	/
2 ea	Part: D5155-047 CO-PILOT HEAD ASSY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150733 PO: PO29893 Line:	Rev: B	✓
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>29/9/15</u> CERTIFIED SIGNATURE: _____ RECEIVER SIGNATURE: _____ 15/9/29 SP			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29893**

Purchase Order Date 9/25/2015

PO Print Date 9/29/2015

Page Number 1 of 3

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	136799	D5155-9 CO-PILOT HEAD REV. B	9/29/2015 Yes 9/29/2015 Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2		2.00 ✓	\$31.25	\$62.50
Line Total:							\$62.50
2	136795	D5155-047 CO-PILOT HEAD ASSY REV. B	9/29/2015 Yes 9/29/2015 Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2		2.00 ✓ 15/9/29 SL	\$31.25	\$62.50
Line Total:							\$62.50
3	135457	646.3313 UPPER GUIDE REV. N/C	9/29/2015 Yes 9/29/2015 FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N		10.00	\$22.50	\$225.00

Note:

9/29/2015

1	d5155-9	BLACK ANODIZE	2	LOT 125.00	
2	D5155-047	BLACK ANODIZE	2		
3	646.3313	HARD BLACK & PRIME	10	LOT 360.00	
4	646.3610	HARD BLACK & PRIME	6		
		REPEAT JOBS		NO	
PO# PO29893					